

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐							
		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 141958

141958

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February 23, 2016 10:20:31 AM

Item ID: D3440-7 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Detent Clip Base (Supersedes B67-43001-221)
 Start Date: 2/23/2016 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 3/1/2016 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10	0		DAS 45 9-89 2016-3-18
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: MEZZ 2 Memo	0.00 0.00				10		MAR 18 2016	DAS 24 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MJ		MAR 18 2016	

MJ MAR 18 2016

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		OTHER : ☐							

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141958

D3440-7

Start Date: 2/23/2016

Required Date: 3/1/2016

Start Qty: 10.00

Required Qty: 10.00

[illegible]

Purchased

No

100

f

27.9970

0.1938

2.04 DAS

M6061T6R1 500X01 250

**

44
9-99

16/03/17

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT003

27.997

m129167

3.997

m134158

24

1.897

DQA: _____ Date: _____



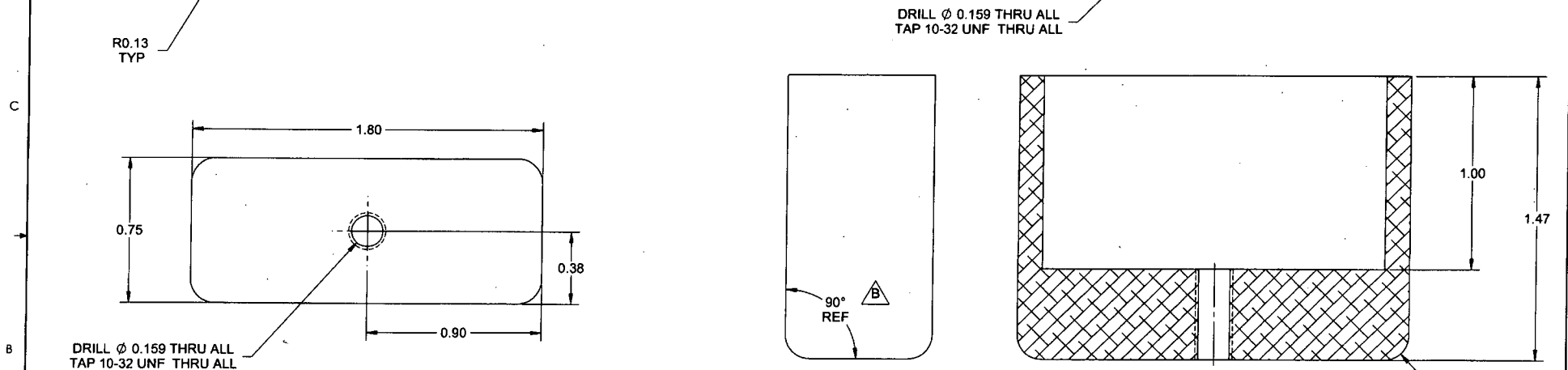
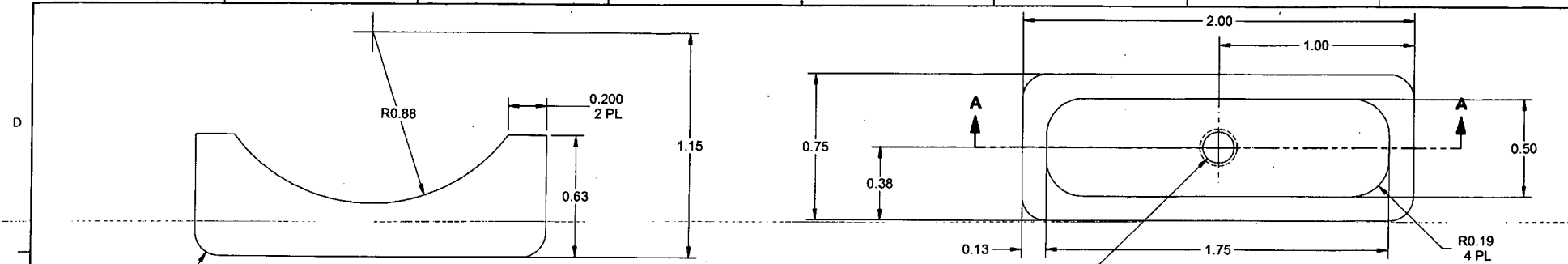
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Misidentified ☐	Past Due ☐																																																																

8 7 6 5 4 3 2 1



**D3440-5 CONTOURED DETENT CLIP BASE
SUPERCEDES PREMIER P/N B67-43001-217**

**D3440-7 DETENT CLIP BASE
SUPERCEDES PREMIER P/N B67-43001-221**

D3440-5/-7 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR PER AMS/QQ/A/200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3440-5=0.05 lb
D3440-7=0.13 lb

141958
20160223

RELEASED
2014-12-08

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	h	DRAWING NO.	REV. B
MFG. APPR.	2/11	D3440	SHEET 2 OF 4
APPROVED	2/11	TITLE	SCALE
DE APPR.	2/11	BLADE FOLD KIT PARTS	NTS
DATE	14.07.22	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

DART AEROSPACE LTD		Work Order:	191958
Description: Detent Clip Base		Part Number:	D3440-7
Inspection Dwg: D3440	Rev: A <i>B</i>	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.75	+/-0.030	1.749	/		Vern	Fk-01
0.13	+/-0.030	.124	/		"	"
0.75	+/-0.030	.746	/		"	"
R0.19	+/-0.030	.1875	/		R-G.	
0.50	+/-0.030	.496	/		Vern	Fk-04
0.13	+/-0.030	.13	/		"	"
1.470	+/-0.010	1.470	/		"	"
2.00	+/-0.030	2.001	/		"	"
R0.13	+/-0.030	.125	/		R-G.	
93°	+/-0.5°					
1.000	+/-0.030	1.000	/		Vern	Fk-04
.38	+/- .030	.375	/		"	"
1.00	+/- .030	.995	/		"	"

Measured by:	DAS 44 9-89	Audited by:	DAS 45 9-89	Prototype Approval:	N/A
Date:	16/03/17	Date:	2016-3-18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.09.19	New Issue	KJ/JLM	<i>[Signature]</i>